

Work Order ID 148716

148716

Page 1

Wednesday, July 06, 2016 8:43:56 AM

Item ID: D3558-11

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket Aft Center

Start Date: 7/4/2016 Start Qty: 8.00 ***8***

Cust Item ID:

Required Date: 7/5/2016 Req'd Qty: 8.00 ***8***

Customer:

Reference:

DAS

Approvals: Process Plan: **21** Date: **JUL 11 2016** Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3558	Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3558 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

16 _____ 2 16/07/25

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

16 _____ 2 16/07/27

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

16 _____ DAS 38 JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By 	
								Lead hand / Supervisor Approval Verification 	
								QC / QA Coordinator Approval 	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____ _____ _____							
Misidentified	☐	Past Due	☐								

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130

Identify as per dwg & Stock Location: FP-001

0.00

130

Packaging

Memo

0.00

Packaging

LOCATION : FP001

x16 q 16/07/29

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

16/07/28DAS
21
9-89

JUL 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Wednesday, July 06, 2016 8:43:55 AM

Page 1

Work Order ID: 148716

148716

Parent Item: D3558-11

D3558-11

Parent Item Name: Gasket Aft Center

Start Date: 7/4/2016

Required Date: 7/5/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07.06.12 EC
IPP Rev:B Rev B dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased		No		100	sf	195.4000	0.654	5.813334			

MNEO60S 063

NEOPRENE SHEET 0.063

all 16/07/27

Location

Loc Qty

Loc Code

MAT052

195.4

M133744

11

M134972

184.4

9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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DART AEROSPACE LTD		Work Order: 148716
Description: Gasket		Part Number: D3558-11
Inspection Dwg: D3558	Rev: B	Page 1 of 1

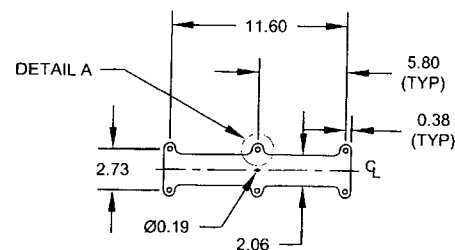
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

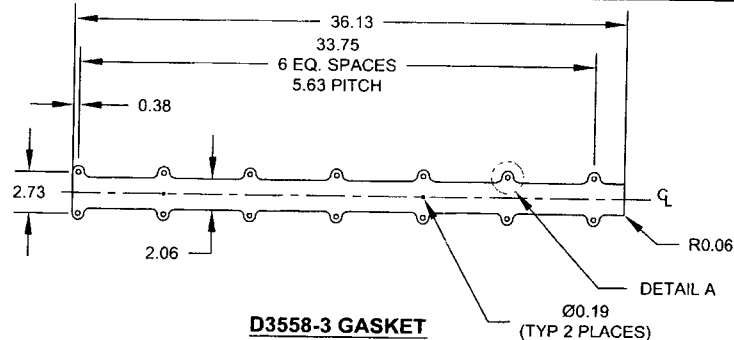
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	Ø.19	1		Tap	
0.30	+/-0.030	.30	1			
0.30	+/-0.030	.30	1			
0.38	+/-0.030	.38	1			
2.06	+/-0.030	2.06	1			
2.73	+/-0.030	2.73	1			
5.50	+/-0.030	5.50	1			
22.50	+/-0.030	22.50	1			
26.50	+/-0.030	26.50	1			

Measured by: <u>De</u>	Audited by: <u>38</u> 9-89	Prototype Approval: N/A
Date: 16/07/27	Date: JUL 27 2016	Date: N/A

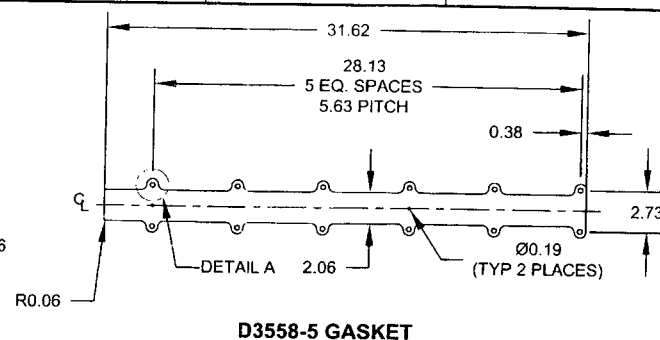
Rev	Date	Change	Revised by	Approved
A	08.07.24	New Issue	KJ/DD	



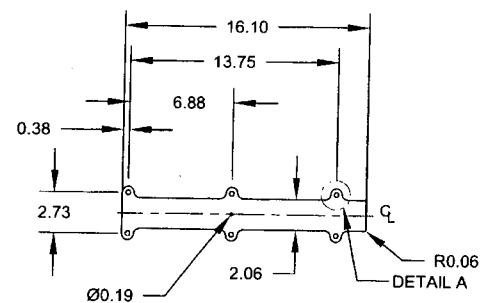
D3558-1 GASKET



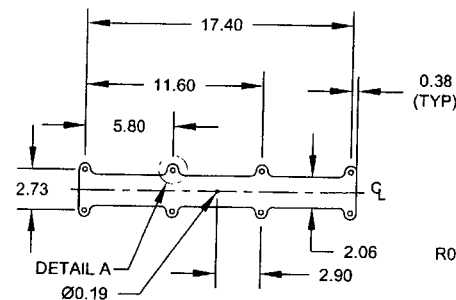
D3558-3 GASKET



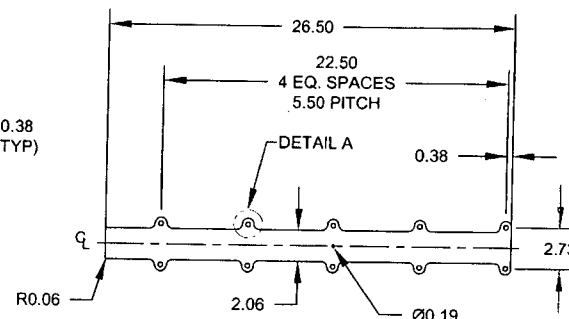
D3558-5 GASKET



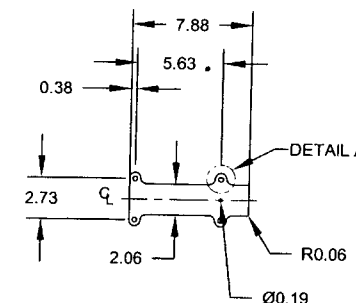
D3558-7 GASKET



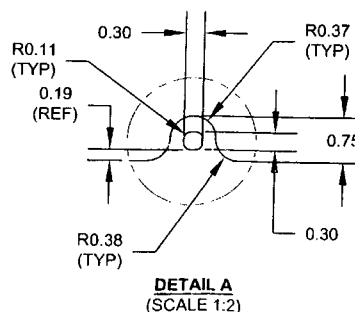
D3558-9 GASKET



D3558-11 GASKET



D3558-13 GASKET



**DETAIL A
(SCALE 1:2)**

- NOTES:**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF. DART SPEC. M-NEW60-S.063)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D3558-1 - 0.09 lbs, D3558-3 - 0.26 lbs, D3558-5 - 0.23 lbs, D3558-7 - 0.12 lbs, D3558-9 - 0.13 lbs, D3558-11 - 0.19 lbs, D3558-13 - 0.06 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 148716 ULS
16-07-11

RELEASED
07.11.16

B	ADD -9/11/13 UPDATE DRAWING FORMAT	PH	07.04.20
A	NEW ISSUE	PH	06.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	24	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	24		
CHECKED	1/1		
MFG. APPR.	1/5		
APPROVED	1/1		
DE APPR.	1/1	DRAWING NO. D3558	
DATE	07.04.20	TITLE GASKET	
		REV. B SHEET 1 OF 1	
		SCALE 1:8	

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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.